

Date: Monday, 05/05/2008 1:15:08 PM  
 User: Julie Lecocq

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SKID TUBE ASSEMBLY  
 Job Number : 39044  
 Estimate Number : 10023  
 P.O. Number :  
 This Issue : 05/05/2008 S.O. No. :  
 Prsht Rev. : NC Part Number : D205634041  
 First Issue : / / Type : SKIDTUBES Drawing Number : D2580 REV D  
 Previous Run : 39043 Project Number : N/A  
 Drawing Revision : D  
 Material :  
 Due Date : 23/05/2008 Qty: 1 Um: Each  
 Written By :  
 Checked & Approved By : JLD 08.5.05  
 Comment : Est Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ  
 Est Rev: O 06.02.28 Added paperwork EC  
 Est Rev:P 07-07-09 SS Wearplates & Gaskets JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy D205-634 bluefile &amp; type labels per PPP D205-634 CHG002

08/05/28 JLD  
 08.5.07

2.0 D25001190 Ext'n -I' Beam Tube 4"



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch  
 1 D2500-1-190 Skid Tube Extrusion B 37544

JO 8-5-6

3.0 D2596 Web, 205 Skidtube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch  
 1 D2596 205 Web B-39059

AWM

8-5-9

4.0 SKIDTUBES 1 SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1- Inspect mat'l D2500-1-190 for damage

2-Cut D2500-1-190 per Dwg D2580 if necessary Deburr ends

3-Acid etch and Alodine tube per QSI 005 4.1

JO 8-5-6

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: SKID TUBE ASSEMBLY

Job Number: 39044

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8-08-05-09

6.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

- 1-Drill pilot holes using drill jig DT 8149(Do not use cutting fluid)
  - 2-Open holes to 0.500" as per Dwg D2580without cutting fluid
  - 3-Countersink holes as per Dwg D2580without cutting fluid
  - 4-Deburr and blow out all chips from inside of tube
  - 5-Bond web in place per QSI 015. Allow 12 Hrs. cure time before cutting
- Pick:
- | Qty                           | Part Number  | Description | Batch |
|-------------------------------|--------------|-------------|-------|
| A/R                           | Sikaflex-291 | 07-107504   |       |
| Sikaflex expire date: 8-10-01 |              |             |       |
| Start Time: 10:10             |              | Date: 8-5-9 |       |
| Fin Time: 10:10pm             |              | Date: 8-5-9 |       |

AWM  
8-5-9

7.0

BENDING

BENDING MACHINE - SKIDTUBES



Comment: BENDING MACHINE

1-Bend as per program D2580.C on CNC Bender and Folio FT009

2-Cut tubes as per Dwg. D2580

8-08-05-13

8.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

- 1-Deburr ends
- 2-Prepare tube for welding, remove alodine as required.

AWM  
8-5-14

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Drawing Name: SKID TUBE ASSEMBLY

Job Number: 39044

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*BE 08/05/14*

10.0

D25763

Step (maching detail)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2576-3	Step	<i>B33321</i>

*BE 08/05/14*

11.0

D2579

Crossbolt Spacer



Comment: Qty.: 20.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
20	D2579	Spacers	<i>B38393</i>

*BE 08/05/14*

12.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

2-Weld step D2576 as per Dwg. D2580 and QSI 004

A/R Aluminum Rod

*M107263 BE 08/05/14*

3-Weld crossbolt spacers D2579 as per Dwg. D2580 and QSI 004.

For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill

A/R Aluminum Rod

*M107263 BE 08/05/14*

4-Grind welds as per Dwg D2580 Grind flush ridge made from bending

5-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64", adjust stopper not to hit web. Debur

6-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580. Debur holes

7-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Debur

8-Drill pilot holes for Tow ring using DT8091, open to .640" and Debur

*SL8-5-15*

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
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Drawing Name: SKID TUBE ASSEMBLY

Job Number: 39044

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

5 08/05/20 (X)

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/05/20 (X)

15.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1  
Pressure wash as per QSI 005

22/BK 08-05-20 (X)

16.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING  
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

9:30 am  
320°F  
10:00 am  
M-L 08/05/21

17.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

YJ 08-05-28 (X)

18.0

D2855

Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cap

Batch:

1338395 YJ

19.0

AN35A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch:

M100188 YJ 08-05-28 (X)

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
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Drawing Name: SKID TUBE ASSEMBLY

Job Number: 39044

Part Number: D205634041

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

20.0	AN960JD10L	Washer
------	------------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: M104885

JSZ

21.0	ALS71032130	Insert
------	-------------	--------



Comment: Qty.: 50.0000 Each(s)/Unit Total : 50.0000 Each(s)

Insert

Batch: M105855

JSZ

22.0	AN3C4A	BOLT
------	--------	------



Comment: Qty.: 50.0000 Each(s)/Unit Total : 50.0000 Each(s)

BOLT

Batch: M1108077

JSZ

23.0	AN960C10L	washer
------	-----------	--------



Comment: Qty.: 50.0000 Each(s)/Unit Total : 50.0000 Each(s)

washer

Batch: M1108077

JSZ

24.0	D356613	Gasket
------	---------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: B32744

JSZ

25.0	D35665	Gasket
------	--------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: B38647

JSZ

26.0	D35661	Gasket
------	--------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

GASKET

Batch: M103392364?

JSZ

08-05-28

(K1)

UN10339425

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Job Number: 39044

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

D356413

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

WEARSHOE

Batch: 1338253

*JS*

28.0

D356411

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

WEARSHOE

Batch: 1338548

*JS*

29.0

D35649

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

WEARSHOE

Batch: 1338656

*JS*

30.0

D35645

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

WEARSHOE

Batch: 1339235

*JS*

31.0

D25943

O-Ring, 205 Skidtube



Comment: Qty.: 16.0000 Each(s)/Unit Total: 16.0000 Each(s)

O-Ring

Batch: 1329908

*JS*

32.0

D25941

Plug, 205 Skidtube



Comment: Qty.: 16.0000 Each(s)/Unit Total: 16.0000 Each(s)

Plug

Batch: 1338950

*JS*

33.0

HAND FINISHING1

HAND FINISHING RESOURCE #1 .



Comment: HAND FINISHING RESOURCE #1

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates

A/R

Sikaflex-291

M1107804

*JS*

08-05-2008

(X)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Drawing Name: SKID TUBE ASSEMBLY

Job Number: 39044

Part Number: D205634041

Job Number:



Seq. #:

Machine Or Operation:

Description :

1- Sikaflex expire date: 08/10

2- Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3- Inspect for foreign object per QSI 024

4- Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive

A/R Sikaflex-291 M107804

Sikaflex expire date: 08/10

5- Wing Walk as per Dwg D2580 and QSI 005 4.4

Batch: M107892

08-05-28

(XL)

34.0

QC5

INSPECT WORK TO CURRENT STEP



S 08/05/28 @



Comment: Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

35.0

PACKAGING 1

PACKAGING RESOURCE #1



(P)

Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-634-041

Location: H

PPP Rev: H

8/5/28

50

36.0

QC21

FINAL INSPECTION/W/O RELEASE



08/05/29/28

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-05-29

B39044

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

**NOTE:** Date & initial all entries

**DART**

DESIGN <i>HH</i>	DRAWN BY <i>PH</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>HH</i>	APPROVED <i>HH</i>	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

**RELEASED**  
07-06-28 *HH*

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

**GENERAL NOTES:**

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:  
SEE NOTES ON  
PAGE 2 FOR D2580-041 AND  
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

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WORK ORDER

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NO. 154

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliot  
Job number: 38940 A  
Part number: D205 634 041  
Description: SKID JUMP 205  
Welding Process: Tig ☒ Mig ☐  
Base material: Aluminium  
Current: AC ☒ DC ☐

TEST REQUIREMENTS AND RESULTS

Visual:  
Penetration:

pass ☒ fail ☐  
pass ☒ fail ☐

UNACCEPTABLE

Cracks:  
Undercut:  
Pin holes:  
Overlap (cold lap)  
Porosity (surface):  
Coloration:

pass ☒ fail ☐  
pass ☒ fail ☐  
pass ☒ fail ☐  
pass ☒ fail ☐  
pass ☒ fail ☐  
pass ☒ fail ☐

Qualifier Del Duval Date of Test Coupon 0805-07

Welder Barclay Elliot Date of Test Coupon 08-05-07

The above named individual is qualified in accordance with AWS D17.1.2001 to weld



RELEASED  
07-06-28

Diagram illustrating the grinding locations for the propeller cross-section. The diagram shows a cross-section of a propeller with the following labels and features:

- GRIND FLUSH (4 PLACES)**: Indicated by four small circles along the top edge of the propeller.
- GRIND FLUSH**: Indicated by a small circle on the left side of the propeller.
- D2576-3 STEP**: Indicated by a line pointing to the top edge of the propeller.
- GRIND FLUSH**: Indicated by a small circle on the right side of the propeller.
- LOCATION RIDGE ON UNDERSIDE OF D2576**: Indicated by a line pointing to the bottom edge of the propeller.
- 1/4**: A dimension line indicating the thickness of the propeller at the bottom right corner.

Diagram illustrating the installation of a D2855 cap on a shaft. The cap is secured with an AN3-5A bolt (1) and an AN960JD10L washer (1) at two locations. The cap is sealed with SIKAFLEX-241/-291. The shaft diameter is indicated as 0.208. The cap thickness is indicated as 0.40.

D2579 SPACER

D2596 WEB (REF)

ALS7-1032-130 (REF)  
(TYP 50 PLACES)

AFTER DRILLING AND BENDING ASSEMBLY  
PERFORM THE FOLLOWING FOR Ø.508 HOLES ONLY:

1. CHAMFER HOLE 0.050 X .45"
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE D2579 SPACER TO Ø.437 X 1.00 DEEP

5

i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

37.50  
DISTANCE TO AFT END  
OF D2596 WEB

3 7

1.750 1.750

0.508 (TYP.)  
(40 PLACES)

REFER TO DETAIL A

8.750 17.375 26.000 34.188 57.313 (REF)  
7 EQUAL SPACES  
8.188 PITCH

38.0 91.500 190.0  
(D2500-1)

REFER TO DETAIL A

Technical drawing of a road cross-section showing a 4% grade and a 20.0m radius curve. The drawing includes dimensions for the distance between the hole and the tangent point (1.0m), the distance between the hole and the tangent point (13.4m), and the distance between the hole and the tangent point (32.0 ± 1.0m). The road width is 11.0m. The drawing is labeled '4' and '20.0'.

[illegible]

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07.02.27

205 SKIDTUBE ASSEMBLY

**DART AEROSPACE LTD.**  
HAWKESBURY, ONTARIO, CANADA

REV. D

D2580

SHEET 2 OF 3

[illegible]

SCALE

205 SKIDTUBE ASSEMBLY

1:24

RELEASED  
07 Dec 28

Diagram illustrating the grinding locations for the D2576-3 step. The diagram shows a cross-section of the step with the following labels:

- GRIND FLUSH (4 PLACES)
- GRIND FLUSH
- D2576-3 STEP
- GRIND FLUSH
- LOCATION RIDGE ON UNDERSIDE OF D2576
- $\frac{1}{4}$

Technical drawing of a bolted joint assembly. The drawing shows a cross-section of a circular component with a central hole. A bolt is shown passing through the hole, secured with a washer and a cap. The drawing includes the following callouts and dimensions:

- DRILL PRIOR TO D2855 CAP INSTALLATION (2 PLACES)**: Points to the two locations where the cap is installed.
- SEAL WITH SIKAFLEX-241/-291**: Points to the sealant applied to the joint.
- AN3-5A BOLT (1)**: Points to the bolt.
- AN960JD10L WASHER (1)**: Points to the washer.
- (2 PLACES)**: Points to the two locations where the washer is installed.
- D2855 CAP**: Points to the cap.
- SEE NOTE ii)**: Points to the joint area.
- 0.40**: Dimension indicating the distance from the center of the bolt to the edge of the component.

5

D2579 SPACER

D2596 WEB (REF)

ALS7-1032-130 (REF)  
(TYP 50 PLACES)

AFTER DRILLING AND BENDING ASSEMBLY  
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE D2579 SPACER TO Ø0.437 X 1.00 DEEP

i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB  
POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

ii) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE  
WITH THE SPACER AT THIS LOCATION

37.50  
DISTANCE TO AFT END  
OF D2596 WEB

3 7

1.750 1.750

Ø0.508 (TYP.)  
(40 PLACES)

REFER TO DETAIL E

REFER TO DETAIL A

8.750 17.375 26.000 34.188

57.313 (REF)  
7 EQUAL SPACES  
8.188 PITCH

38.0 91.500 190.0  
(D2500-1)

[illegible]

0.5

1.5

1.5

H

NO C'BORE  
NO PLUG

REFER TO DETAIL G

BLACK ANTI-SKID TO 0.5  
ABOVE LOCATION RIDGE

NO C'BORE  
NO PLUG

8

1.5

1.5

1.5

WELD AS PER DETAIL F

BLACK ANTI-SKID TOP OF STEP  
TO 0.5 ABOVE BOTTOM EDGE

NO C'BORE  
NO PLUG

D3566-1

D3566-5

D3566-1

D3566-13

D3564-11

D3564-5

D3564-9

D3564-13

ANCHOR BOLT (1)

AN960C10L WASHER (1)

(50 PLACES)



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DRAWING NO.
D2580

TITLE
205 SKIDTUBE ASSEMBLY

**DART AEROSPACE LTD.**  
HAWKESBURY, ONTARIO, CANADA

REV. D  
SHEET 3 OF 3  
SCALE  
1:24

